

Split
ship July 15
Work Order ID 60166 -1

June 28, 2010 11:51:52 AM



Page 1

Item ID: D4134-041

Revision ID:

Item Name: Wearplate: LH Aft

Start Date: 6/29/10

Start Qty: 3.00

Required Date: 7/15/10

Req'd Qty: 2.00

Reference:

Approvals:

Process Plan:

QC:

Date: 10/6/29 Tooling:

Date: SPC (Y/N):

Date:

Date:

Setup Start

Stop

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4134

A

100



Waterjet

FLOW CNC Waterjet

304 050

FLOW WATERJET

Memo

1-Cut D4134-1F as per Dwg D4134

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

Deburr 7 min 10/06/29 (3x)

QC2- Inspect parts off machine FAI/FAIB

0.00

110



QC

Quality Control

Memo

0.00

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

8 10/06/30

BIO 6-29

3

BIO 6-29

3

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60166

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Item ID: D4134-041
 Revision ID:
 Item Name: Wearplate, LH Aft
 Start Date: 6/29/10 Start Qty: 2.00
 Required Date: 7/15/10 Req'd Qty: 2.00
 Reference:

Accept



Setup Start
 Stop



Cust Item ID:
 Customer:

Approvals: Process Plan:
 QC:

Date:
 Date:

Tooling:
 SPC (Y/N):

Date:
 Date:

Run Start
 Stop



Sequence ID/
 Work Center ID

Operation
 Description

Set Up/
 Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

130



Brake NC
 Brake NC

Form as per dwg
 NC BRAKE

0.00

Memo

1- Form using DT 8179 Die as per Dwg D4134

0.00

Di 9641

Sig 10/07/13

③

910

B 6-07-13 - one only

140



QC
 Quality Control

QC'S- Inspect part completeness to step on W/O

0.00

Memo

0.00

P 10-07-14 ①

150



Large Fab
 Large Fab

Weld per dwg A/R Hardcoat S.S. Batch: 1114705
 Large Fab

0.00

Memo

Weld hard surface using DT n/a as per QSI 004 and Dwg D4134

0.00

10-07-15 1 φ

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Order ID 60166

010 11:54:53 AM



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D4134-041

Accept



Setup Start



Stop



D:

e: Wearplate, LH Aft

e: 6/29/10

Start Qty: 2.00

Date: 7/15/10

Req'd Qty: 2.00



Cust Item ID:

Customer:

S: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



ID/
ater ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

8/10/15

(X)

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

10-07-14

Grey Sandtex(Ref:4.3,5,6) per QSI005 4.3

0.00

Memo

0.00

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

12:00:30
12:30

10-7-15

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 60166

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Item ID: D4134-041
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Item Name: Wearplate, LH Aft
Start Date: 6/29/10 Start Qty: 2.00
Required Date: 7/15/10 Req'd Qty: 2.00
Reference:

Accept



Setup Start



Stop



Cust Item ID:
Customer:

Approvals: Process Plan:
QC:

Date:
Date:

Tooling:
SPC (Y/N):

Date:
Date:

Run Start
Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

200



Small Fab

0.00

Small Fab

Memo

0.00

1- Bond D4134-3 gasket to inner surface of wearplate using a thin layer of 3M 1300/1300L scotch grip adhesive
Batch: MH3174

= 7m, h w/07/15 (12)

210



QC

QC5- Inspect part completeness to step on W/O

0.00

Quality Control

Memo

0.00

10-07-15 @

Work Order ID 60166

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Item ID: D4134-041

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Start Date: 6/29/10

Start Qty: 2.00

Required Date: 7/15/10

Req'd Qty: 2.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

220

Identify as per dwg & Stock Location: _____

0.00



Packaging

Packaging

Memo

0.00

Packaging

Paul 7/16

230

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

10-7-16

MF 10-7-16

Picklist Print

June 28, 2010 11:51:51 AM

Page 1

Work Order ID: 60166

Parent Item: D4134-041

Parent Item Name: Wearplate, LH Aft



Start Date: 6/29/10

Required Date: 7/15/10

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.06.25 new issue DD ver:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4134-3 		Manufactured	No			200	Each	0.0000	1	2.000200			
Gasket M304S18GA 		Purchased	No			100	SF	132.8779	1.5825	3.165317			

304/316 .050 Sheet

Location

MAT20

Loc Qty

132.8779

111743

8.86

112885

28.0179

113062

96

Loc Code

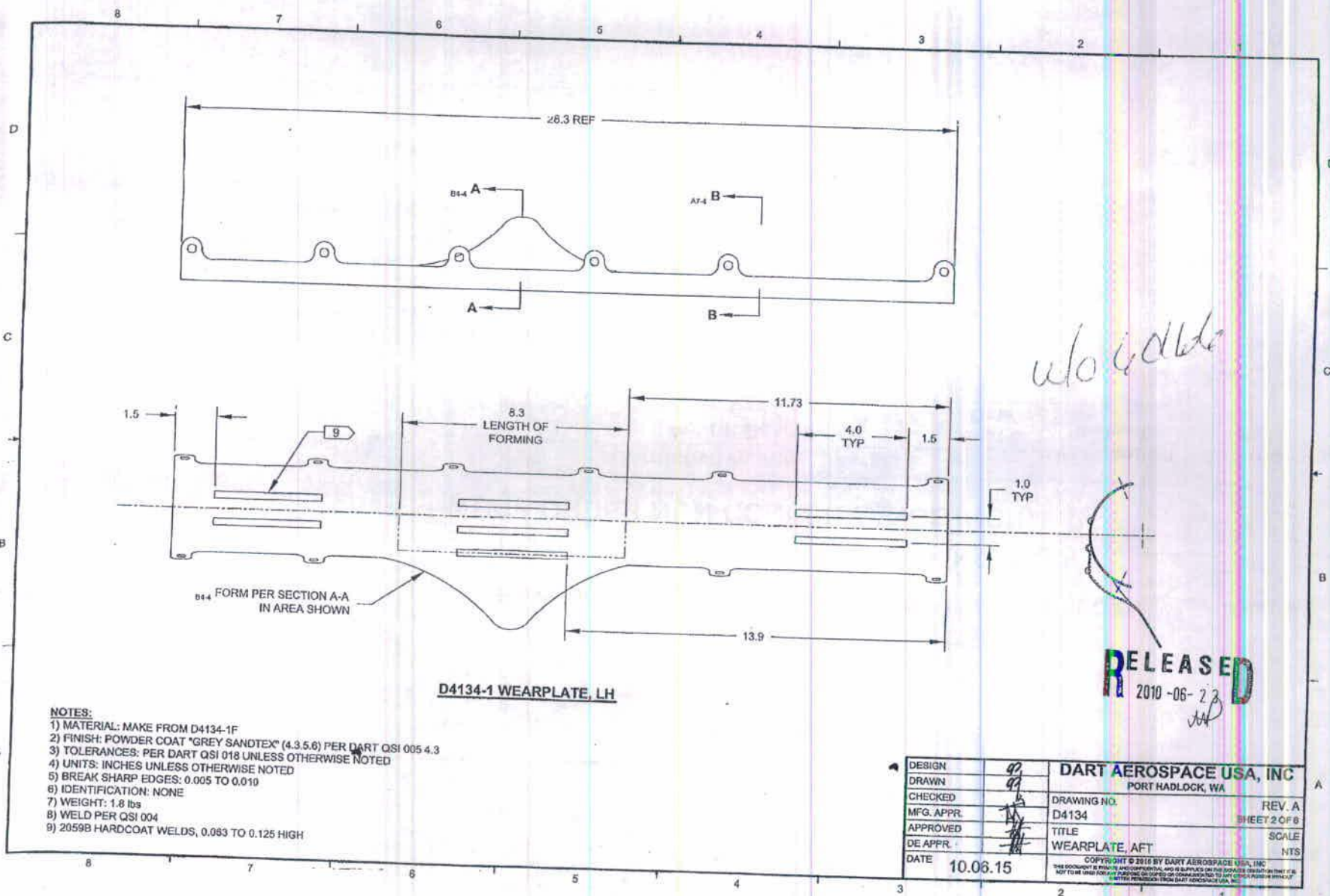
B10-6-24

③

①X m-h 10/07/15

4.8

113062



W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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RELEASED
2010-06-23

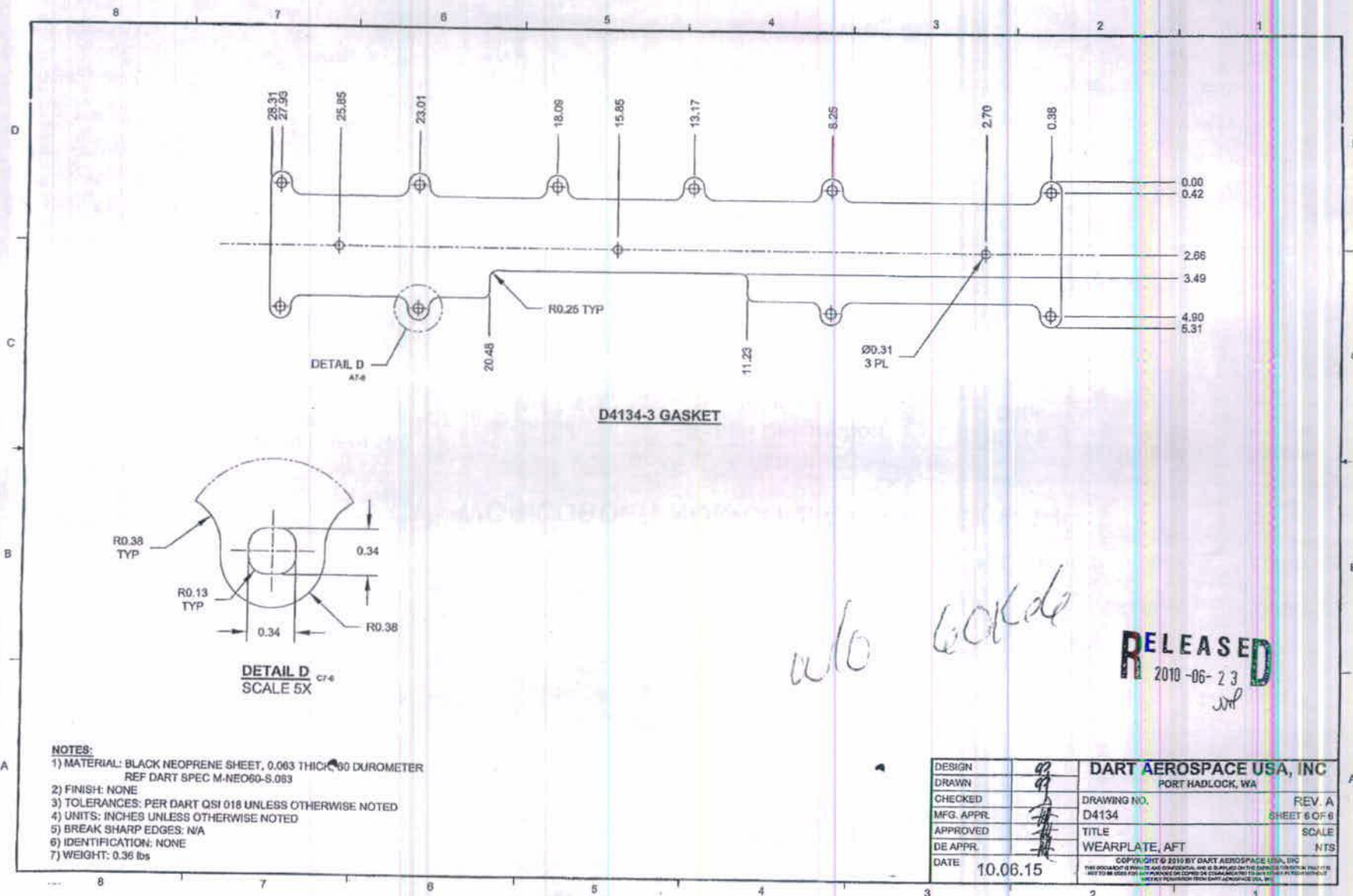
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DART AEROSPACE LTD		Work Order: 60166
Description: WEAR PLATE LH AFT		Part Number: D4134-041
Inspection Dwg: D4134-1 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.300	+/- .005	.303				
.300	+/- .005	.303				
.415	+/- .005	.412				
.82	+/- .005	.816				
2.74	+/- .005	2.735				
4.65	+/- .005	4.640				
5.055	+/- .005	5.053				
5.47	+/- .005	5.468				
.703	+ .005 - .001	.705				
.375	+/- .005	.374				
5.85	+/- .005	5.85				
8.74	+/- .005	8.750				
13.170	+/- .005	13.170				
15.85	+/- .005	15.85				
18.092	+/- .005	18.092				
23.003	+/- .010	23.013				
25.85	+/- .005	25.85				
27.94	+/- .005	27.934				
28.31	+/- .005	28.310				
8.05	+/- .005	8.048				
15.73	+/- .005	15.73				
15.98	+/- .005	15.98				
.050	+/- .010	.050				

all
for
this
D.A.
8
w/valve

Measured by: IB	Audited by: S	Prototype Approval: N/A
Date: 10-6-29	Date: 10/04/30	Date: N/A
Rev A	Date	Change
		New Issue
Revised by KJ/JLM	Approved	

W/O:			WORK ORDER CHANGES					
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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/07/13	130	Had to open hole at .311 to match the jig	Sr	10/07/13	3	10/07/13 P. J. L. W.	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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